

Work Order ID 72386-2 *Split 3*

Monday, July 25, 2011 9:17:18 AM



Item ID: D4360-041

Revision ID:

Item Name: Wearplate Assembly

Start Date: 7/25/2011 Start Qty: 8.00 *2*

Required Date: 8/2/2011 Req'd Qty: 8.00

Reference:

Accept



Setup Start

Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

QC:

Date: *7/25/11*

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D4360

B

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg (D4360-1)

Dwg Rev: *8*

Prog Rev: *1*

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*13/1-8-11*

*11/11*

*13/1-8-11*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/

Work Center ID

Operation

Set Up/

Run Hours

Tool ID

Tool #

Plan

Accept

Qty

Reject

Reject

Number

Insp.



120

QC

Quality Control

Memo

QC8- Inspect parts - second check

0.00

8/10/11



130



Large Fab

Large Fab

Memo

1- Weld cups as per dwg

0.00

M114509

2- Apply hardfacing on wearplate as indicated on dwg

A/R HARRICOAT 2059B BATCHE: M120892



140

QC

Quality Control

Memo

QC5- Inspect part completeness to step on W/O

0.00

8/12/11





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# Work Order ID 72386

Monday, July 25, 2011 9:17:18 AM



Page 3

Item ID: D4360-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate Assembly

Start Date: 7/25/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 8/2/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

Pl 12.03.05

2x Ø

160

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

12/3/6 2x Ø

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

12/3/6 2x Ø

ME  
12.03.04

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# Picklist Print

Monday, July 25, 2011 9:17:44 AM

Page 1

Work Order ID: 72386

Parent Item: D4360-041

Parent Item Name: Wearplate Assembly



Start Date: 7/25/2011

Required Date: 8/2/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 11.04.11 NEW ISSUE DD VER:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA

Purchased

No

100

sf

219.4000

0.97867

8.241432

14



304/316 Sheet .063



(B1-E-1)

Location

Loc Qty

Loc Code

MAT020

19.4

117275

1.7

117653

17.7

MAT021

200

118217

200

D4379-1

Manufactured

No

130

Each

0.0000

12

96



Wearplate Cup



101 D-1, 11

D4360 1

B 67717 20

22 12 1-30

3

D4379-1

B 77649 x 108

EL 12-3-2



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ITEM	QTY	P/N	DESCRIPTION
	.041		
	X	D4360-041	206L/407 WEARPLATE ASSEMBLY
1	1	D4360-1	206L/407 WEARPLATE
2	12	D4379-1	WEARPLATE CUP
3	NR	2059B	HARDCOAT

RELEASED  
2011-05-15  
AJ

D4360-041 206L/407 WEARPLATE ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4360-041" AND B/N "BXXXXX"  
PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 2.10 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 12 PL

B	SHT 3 LIGHTENING HOLES DELETED, SHT 2 ZONE B.3 HARDCOAT RELOCATED. REASON: PROTECTION OF BEARPAW		AJS	11.05.13
A	NEW ISSUE		AJS	11.03.22
REV	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD		
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B	
MFG. APPR	<i>[Signature]</i>	D4360	SHEET 1 OF 3	
APPROVED	<i>[Signature]</i>	TITLE	SCALE	
DE APPR	<i>[Signature]</i>	206L/407 WEARPLATE ASSEMBLY	NTS	
DATE	11.05.13	COPYRIGHT © 2011 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS UNCLASSIFIED AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM.</small>		



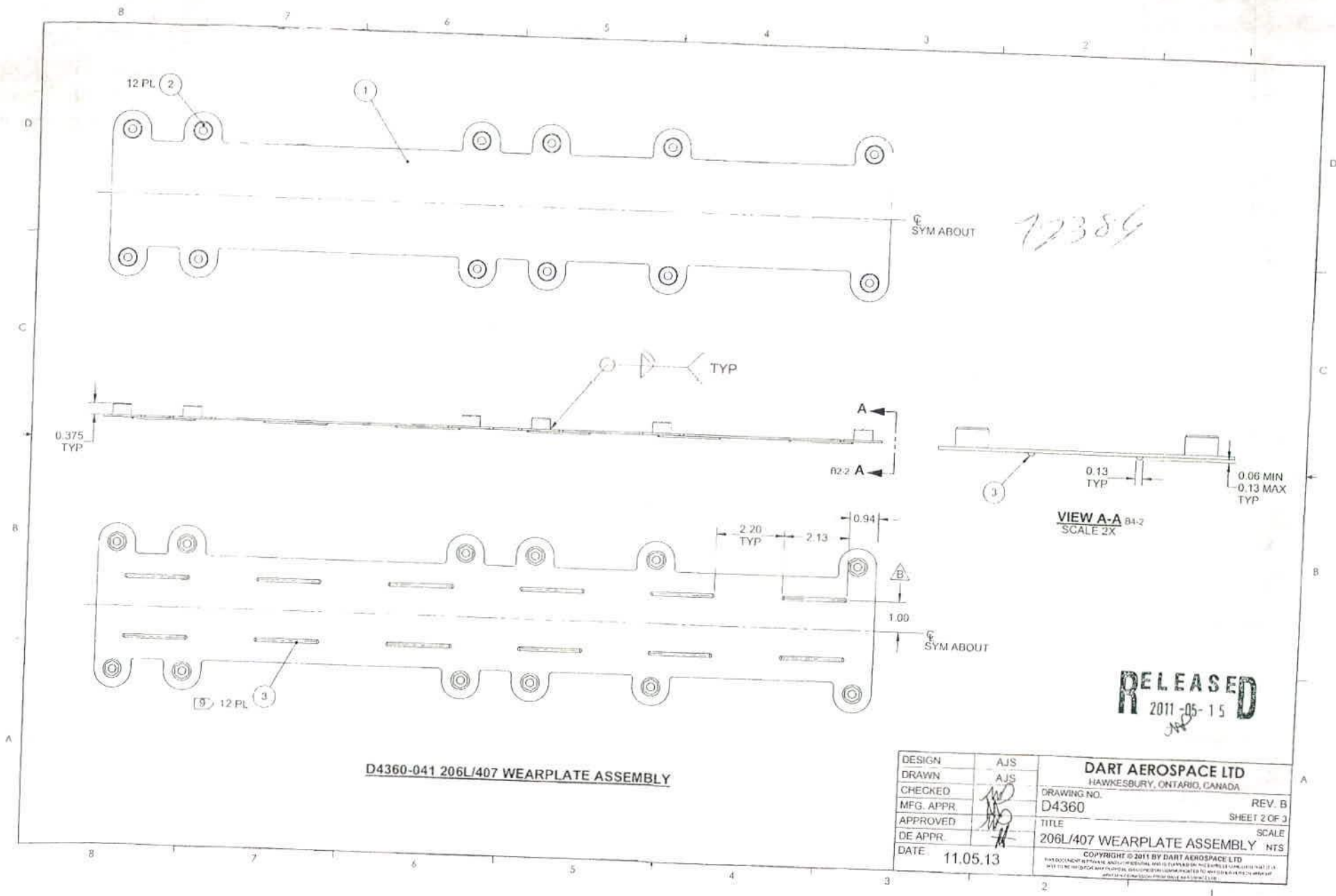
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DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D4360</b> TITLE <b>206L/407 WEARPLATE ASSEMBLY</b> SCALE <b>NTS</b> REV. B SHEET 2 OF 3 COPYRIGHT © 2011 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND UNCLASSIFIED. IT IS FORWARDED ON THE SUPPLIER'S COMPLIANCE WITH IT. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM.</small>
DRAWN	AJS	
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
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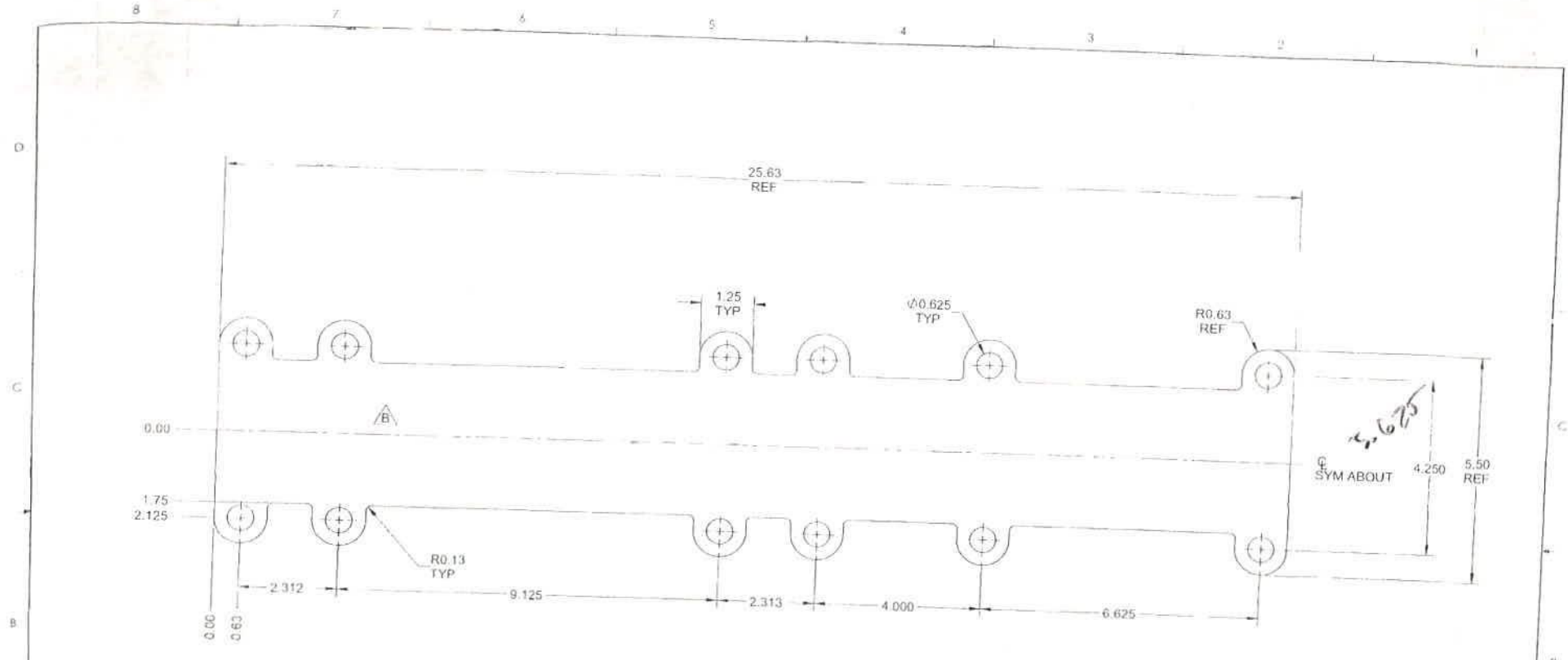
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ENGINE 542



D4360-1 206L/407 WEARPLATE

12386

RELEASED  
2011-05-15  
MR

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)  
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240  
REF DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.81 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED	MR	DRAWING NO.	REV. B
MFG. APPR.	MR	D4360	SHEET 3 OF 3
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